

Date: Wednesday, 2/8/2006 1:22:52 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TOP
Job Number	: 25743		
Estimate Number	: 10878		
P.O. Number	: N/A	Part Number	: D32491
This Issue	: 2/8/2006 S.O. No. : N/A	Drawing Number	: D3249 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 25723	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 2/28/2006
Checked & Approved By	: [Signature]	Qty:	20 Um: Each
Comment	: Est. B 04.10.26 D3249-1 no longer made in-house		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 535

Fabricate D3249-1 as per Dwg D3249

Possible supplier: Industrial Laser

Material release note is required

u 06.02.08

2.0	D32491B	Top
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
 Top

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

PO 4/6

(20)

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

[Signature]

20

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

JAD

06.05.08

M.F. 06-05-08

(20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 17 Date: 06/05/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP

Job Number: 25743

Part Number: D32491

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

060509

(20)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m.p. 06-05-09

(20)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

a.m 06-05-15

(20)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/05/17

(20)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5728

AR

20

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/18

(20)

Job Completion



060518

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Quotation

#7 - 7504 Vantage Place

Delta, B.C. V4G 1A5

PH: (604) 946-4152

FAX: (604) 946-4153

Date: 08-Feb-06

Company: DART AEROSPACE

To: LINDA LACELLE

From: JEFF MOSTAT

Quote No.: DA-020806-01

Part No: AS SHOWN

EMAIL: jeff@industriallaser.com

Quantity	PART DESCRIPTION	Cut Charge	Form Charge	Material Charge.	Part Charge.		Lot Charge
20	D3249-C1	\$22.00	\$2.00		\$24.00	ea.	\$480.00
20	D3250-C1	\$32.00	\$2.00		\$34.00	ea.	\$680.00
	material (on Dart Acct.)						
	*4 sheets 4' x 12' 2024 T3						
4	-Bare (2 weeks delivery)			\$392.00		ea.	\$1,568.00
4	-Alclad (available now)			\$444.00		ea.	\$1,776.00
	(Copper&Brass supplies)						
	*nesting utilizes 3.5 sheets						

TOTAL CHARGE THIS QUOTATION: n/a

G.S.T.: n/a

P.S.T (IF APPLICABLE): n/a

TOTAL ORDER CHARGE: n/a

TERMS AND CONDITION.

Prices good for 10 days.

F.O.B. our plant, taxes out

Terms: net 30 days with account, COD without

LEAD TIME (WORKING DAYS):

Please complete order
information below and fax return to I.L.C.

P.O. Number:

Date:

P.S.T. No.:

Signature:

Mostat
Handwritten signature

Handwritten signature
06/04

25703

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA

DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.
Per:

Mark J. Vrabiec

Mark J. Vrabiec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

525383

306094

Ship Date

B.L. No.

Invoice No.

Alcoa No. Item

Page 0

2005-11-07

87255

42246

DS-90097-1

P.O. No./Govt Contract No.

Customer

CG1887

C&B-WHS-SCHAUMBERG

TOTAL COPIES: 2. WITH SHIPMENT

COPPER AND BRASS SALES
22355 WEST ELEVEN MILE RD
SOUTHFIELD, MI 48034

COPPER & BRASS SALES, INC.
415 STATE PARKWAY
SCHAUMBURG, IL 60195

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C&B-WHS-SCHAUMBERG

Alcoa No. Item

DS-90097-1

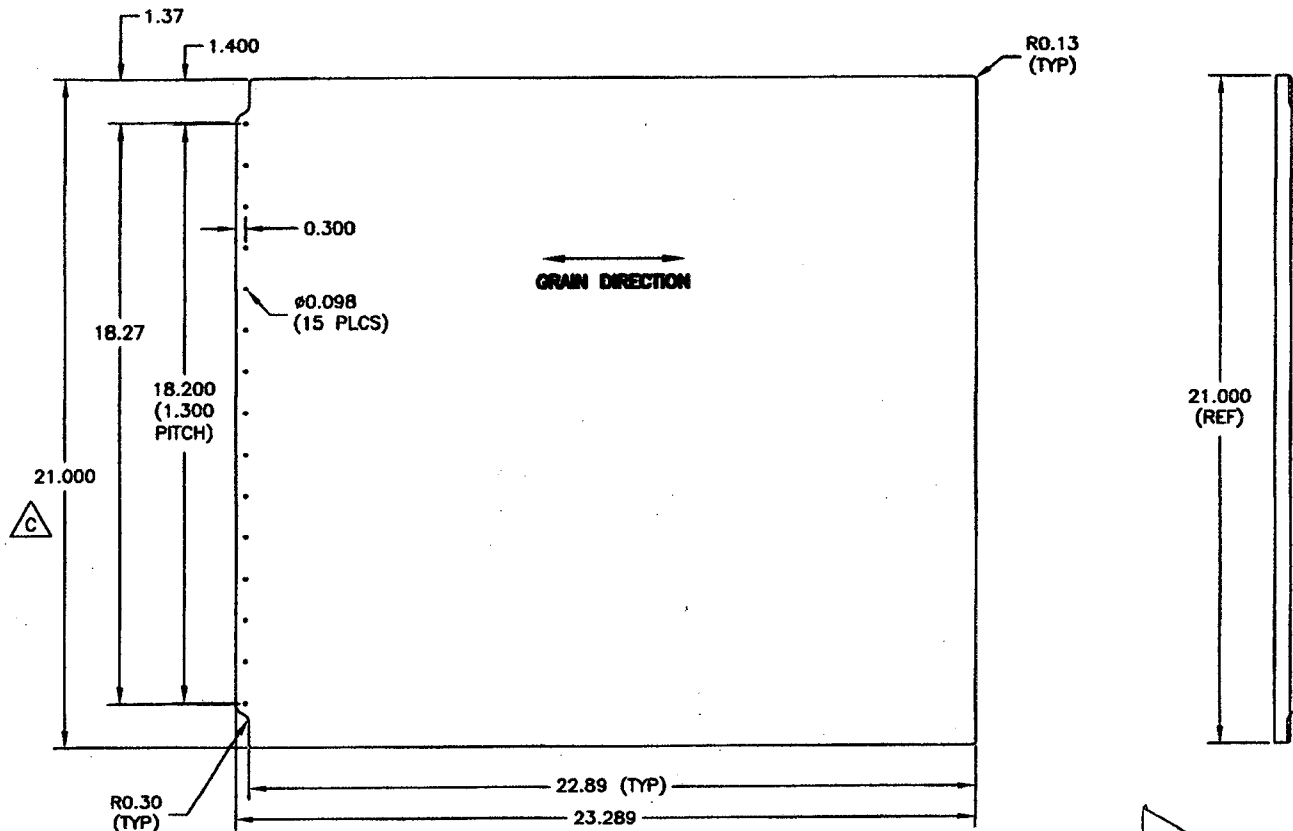
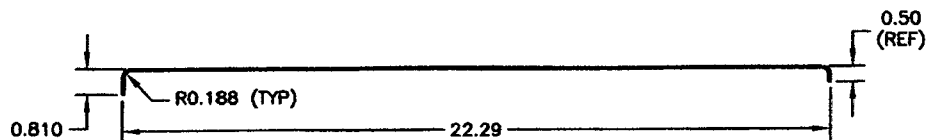
Page 2

Lot: 481111 - Mechanical, Physical, Metallography, Quantometer Results (cont.) -----
Cast Number Chemical SI FE CU MN MG CR ZN TI
H9214012 Actuals .07 .14 4.6 .63 1.6 .00 .06 .03

DART

DESIGN RF	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3249	REV. C SHEET 1 OF 1
DATE 06.02.01		TITLE TOP (DUAL BATTERY RACK)	SCALE 1:6
A	04.04.06	NEW ISSUE	
B	04.11.04	20.625 WAS 20.245	
C	06.02.01	21.000 WAS 20.625, REMOVE $\phi 0.501$ TOOLING HOLES	

RELEASED
06.02.13 *[Signature]*

**D3249-1F FLAT PATTERN****D3249-1 BEND DETAIL****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

REFERENCE ONLY

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